Work Order ID 123155

Tuesday, July 29, 2014 2:32:46 PM

123155

Item ID: D4008-5 **Accept** *N9000401100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fuel Filler Splash Guard Hinge Half

Start Date: 7/29/14 **Start Qty:** 4.00 *4*

Required Date: 7/29/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** J.A **Date:** 14/07/30 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4008 / D									
100		0.00							
100						4X			14/09/10 DAS 36 9-89
Small Fab	**Memo**	0.00							
Small Fab	1- Cut MS20257-3 hinge as per dwg D4008, keep 2nd half for D4008-11								
	2- Driil holes as per dwg								
	3- Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00			DAS 30 9-89				
110						4			14/09/10
QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4008-5 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fuel Filler Splash Guard Hinge Half
Start Date: 7/29/14 **Start Qty:** 4.00 *4*
Required Date: 7/29/14 **Req'd Qty:** 4.00 *4*
Reference:
Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: GA	0.00							
120						4			14/09/10
Packaging	**Memo**	0.00							
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130						MLS	14-09-11		
QC	**Memo**	0.00							
Quality Control									

MF
14-9-10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Picklist Print

Tuesday, July 29, 2014 2:32:45 PM

Work Order ID: 123155 *123155*

Parent Item: D4008-5 *D4008-5*

Parent Item Name: Fuel Filler Splash Guard Hinge Half

Start Date: 7/29/14 **Required Date:** 7/29/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by: DD IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC IPP REV:D 14.06.12 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200		Purchased	No			100	f	57.5420	0.377	2			DAS 36 9-89
MS20257-3-7200 PIANO HINGE									**			14/09/10	

Location	Loc Qty	Loc Code	
ST209a	57.542		
m127172	12.6		
m127393	9.442		
m128401	4		
m128813	0.5		
m128923	31		2

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

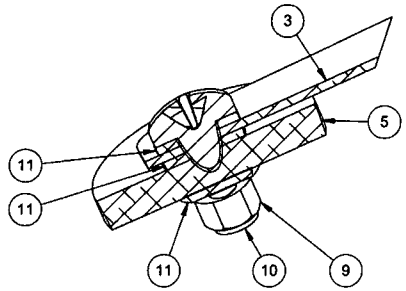
Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

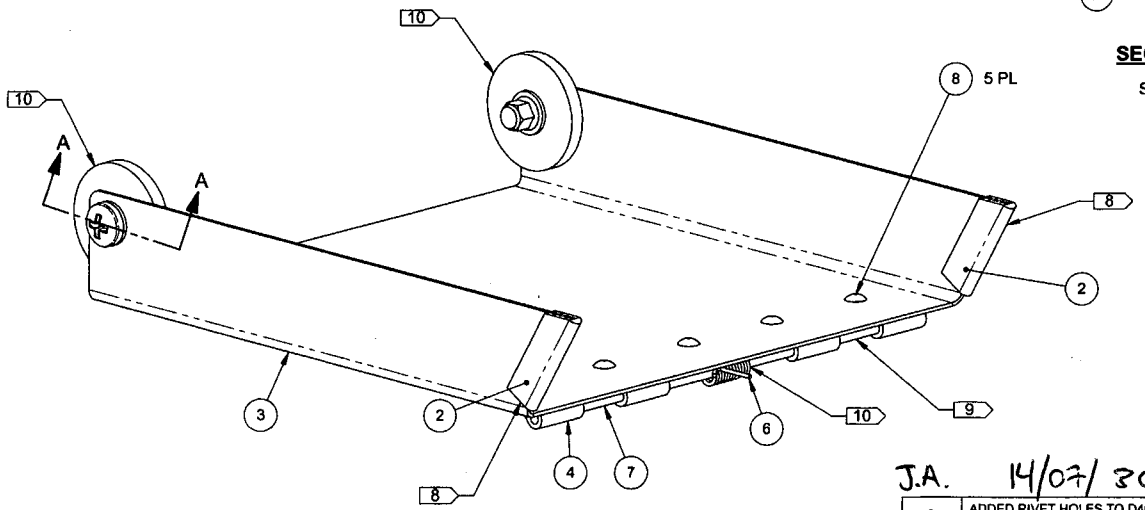
General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-041	AUX TANK FILLER SPLASH GUARD ASSEMBLY	JCA-M47-2-26
2	2	D3941-1	RUBBER CUSHION	
3	1	D4008-1	FUEL FILLER SPLASH GUARD CHANNEL	
4	1	D4008-5	HINGE HALF	
5	2	D4008-7	WASHER	
6	1	D4008-9	SPRING	
7	1	MS20001-4	PIN	
8	5	MS20470AD3-3	RIVET	
9	2	MS21042L08	NUT	
10	2	MS35206S245	SCREW	
11	6	NAS1149DN832J	WASHER	



SECTION A-A
2 PL
SCALE: 2X



D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY

RELEASED
2014 -06- 11

J.A. 14/07/30 123153

NOTES: D
1) MATERIAL: N/A
2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2
PAINT GREY (4.2.2.3) PER DART QSI 005 4.2.2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: 0.15 lbs
8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER PRIME AND PAINT
9) MASK HINGE PIN AREA BEFORE PRIME AND PAINT
10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER PRIME AND PAINT

REV.	DESCRIPTION	BY	DATE
D	ADDED RIVET HOLES TO D4008-11 (C7-10) UPDATED NOTES ON ALL SHEETS	ML	14.05.13
C	CHANGE POWDER COAT FROM "GREY SANDTEX" TO "ANSI 61 GREY"; CORRECT MATERIAL ERROR, ZN A7-6. ADD D4597-1 TO D4008-043, ZN C4-2.	DC	12.01.17
B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05

APPROVED

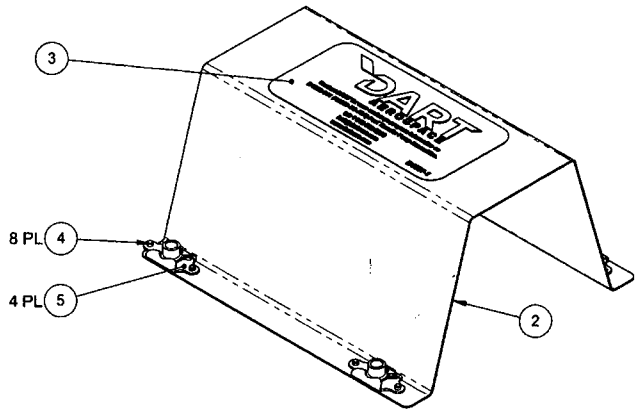
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MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4008 REV. D
SHEET 1 OF 10
TITLE SPLASH GUARD SCALE NTS

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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	1	D4597-1	PLACARD	
4	8	MS20427M3-3	RIVET	
5	4	MS21059L4	NUT PLATE	



D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY

RELEASED
2014 -06- 11

NOTES: (D)
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
7) WEIGHT: 0.47 lbs

APPROVED

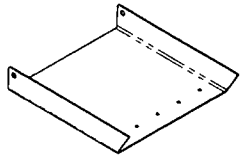
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MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

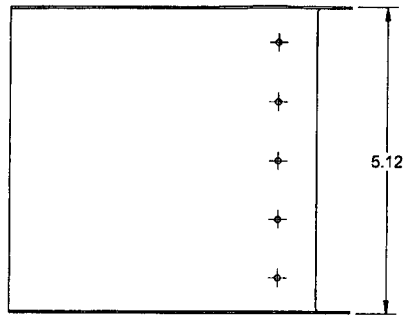
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HAWKESBURY, ONTARIO, CANADA

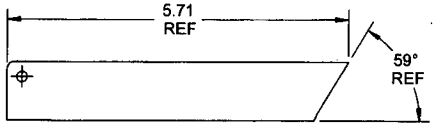
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SHEET 2 OF 10
TITLE SPLASH GUARD
SCALE NTS

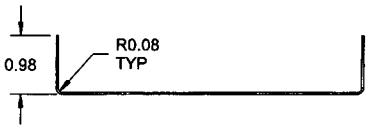
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-1	REF JCA-M47-2-26









D4008-1 FUEL FILLER SPLASH GUARD CHANNEL
MAKE FROM D4008-1F

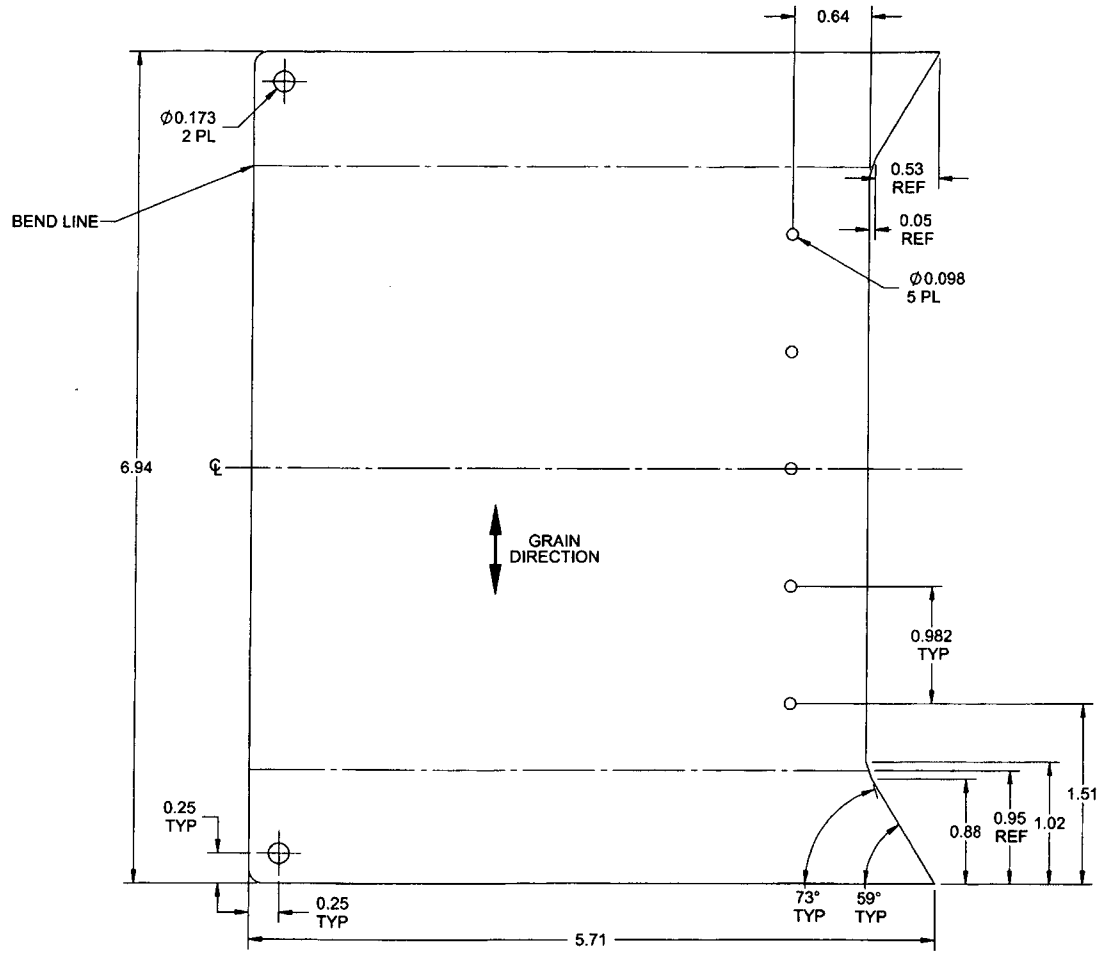
RELEASED
2014 -06- 11

NOTES: (D)
1) MATERIAL: MADE FROM D4008-1F
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.11 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	AP	DRAWING NO. D4008 REV. D
MFG. APPR.	JLM	SHEET 3 OF 10
APPROVED	MP	TITLE SPLASH GUARD SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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D4008-1F FLAT PATTERN

RELEASED
2014 -06- 11

NOTES:
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.032
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.11 lbs

APPROVED

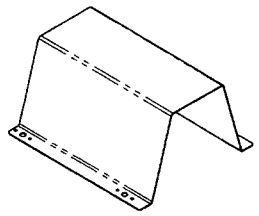
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CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

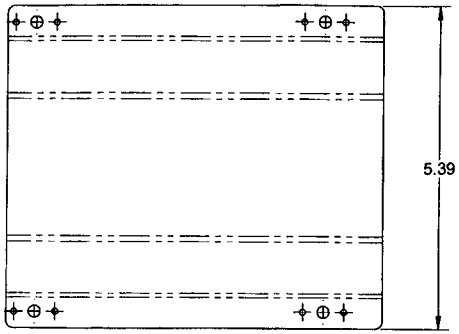
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HAWKESBURY, ONTARIO, CANADA

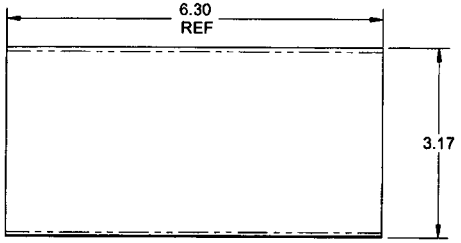
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SHEET 4 OF 10
TITLE SPLASH GUARD
SCALE NTS

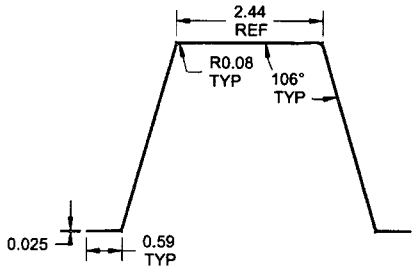
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-3	REF JCA-M47-2-29









D4008-3 FUEL PUMP SPLASH GUARD COVER
MAKE FROM D4008-3F

RELEASED
2014 -06- 11

NOTES: (D)
1) MATERIAL: MADE FROM D4008-3F
2) FINISH: POWDER COAT "ANSI 61 GREY" (4.3.5.15) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.45 lbs

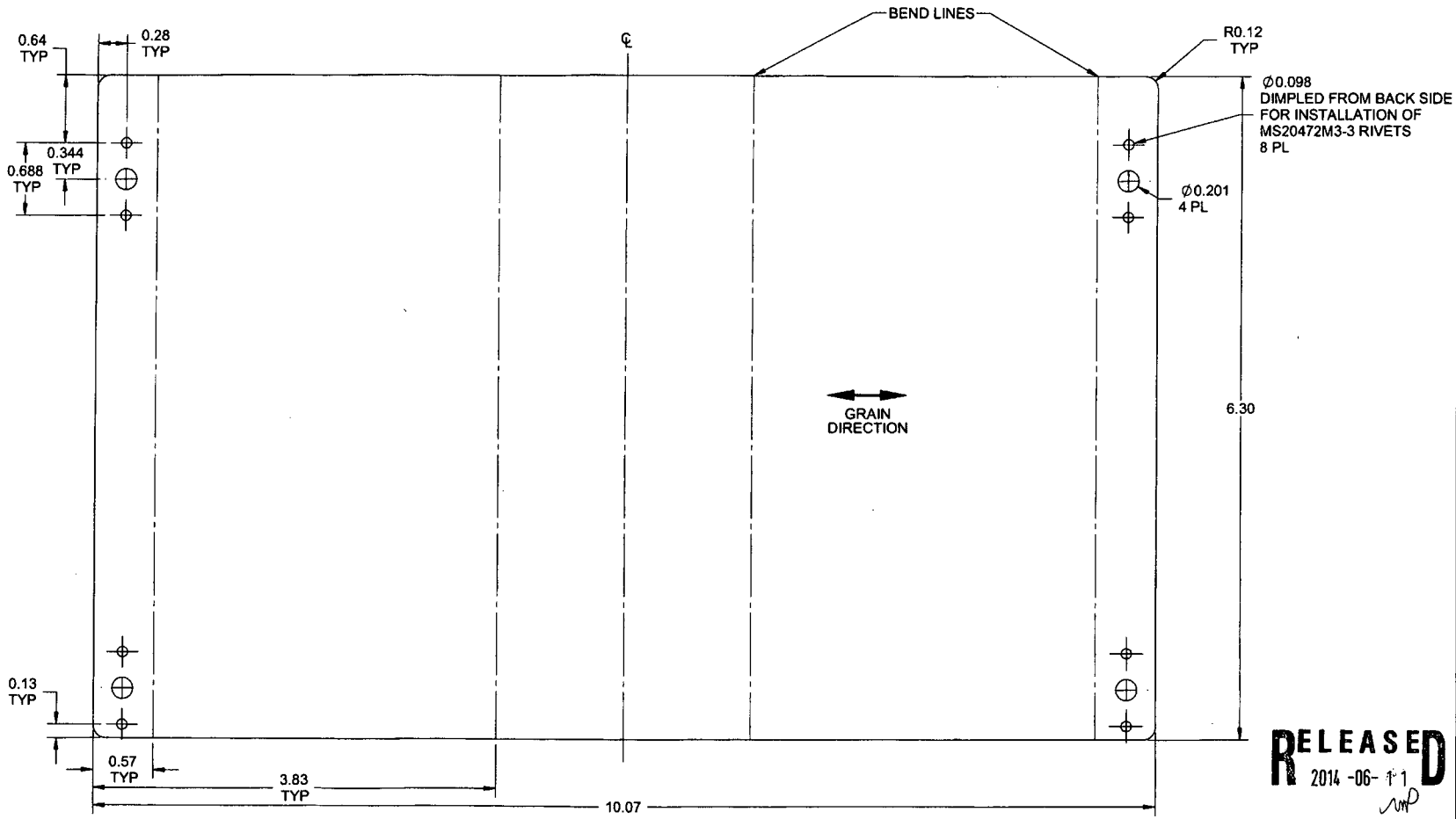
APPROVED

DESIGN	ML
DRAWN	ML
CHECKED	AP
MFG. APPR.	JLM
APPROVED	MP
DE APPR.	DS
DATE	14.05.13

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4008 REV. D
SHEET 5 OF 10
TITLE SPLASH GUARD
SCALE NTS

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RELEASED
2014 -06- 11

D4008-3F FLAT PATTERN

NOTES: (D)
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.025 THICK
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM A240 OR ASME SA240
REF DART SPEC M304S24GA
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.45 lbs

APPROVED

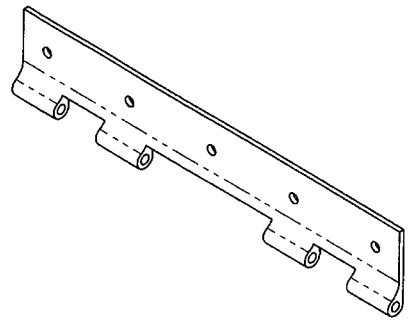
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APPROVED	MP
DE APPR.	DS
DATE	14.05.13

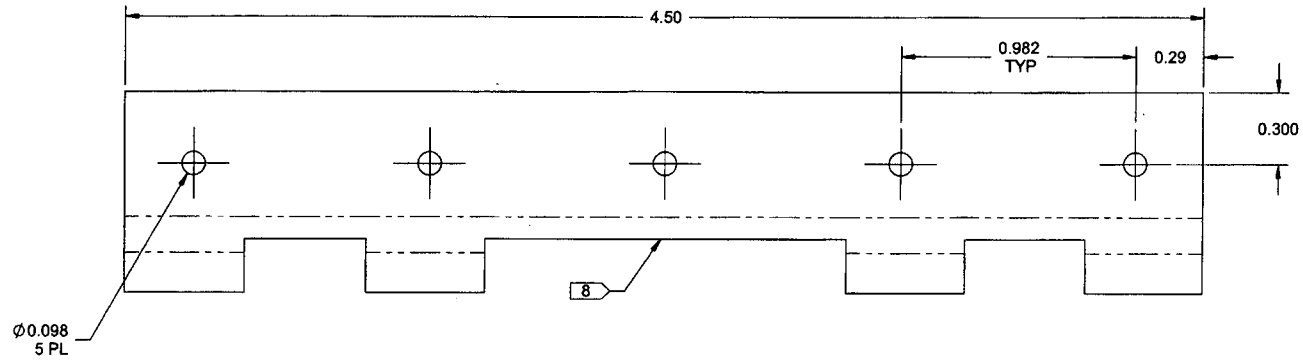
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4008 REV. D
SHEET 6 OF 10
TITLE SPLASH GUARD SCALE NTS

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-5	REF JCA-M47-2-26





D4008-5 HINGE HALF

RELEASED
2014 -06- 11

NOTES: (D)
1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.02 lbs
8) REMOVE CENTER LUG FROM THIS AREA, FLUSH WITH THIS EDGE

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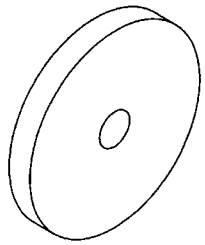
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DATE	14.05.13

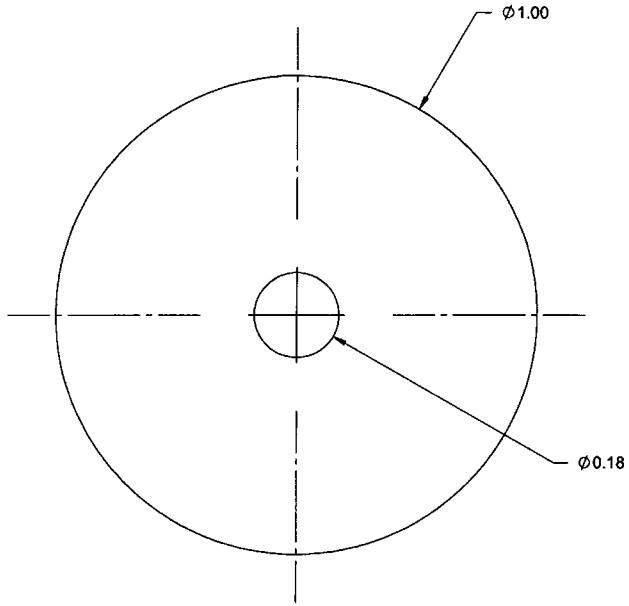
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

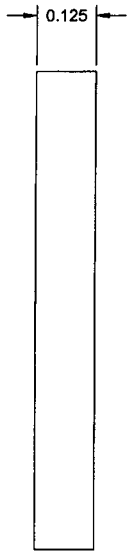
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-7	REF JCA-M47-2-26







D4008-7 WASHER

RELEASED
2014 -06- 11

NOTES: (D)
1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, Ø1.00 ROUND BAR, BLACK
REF DART SPEC M-DELRIN-R1.000
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: LESS THAN 0.01 lbs

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DATE	14.05.13

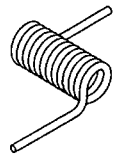
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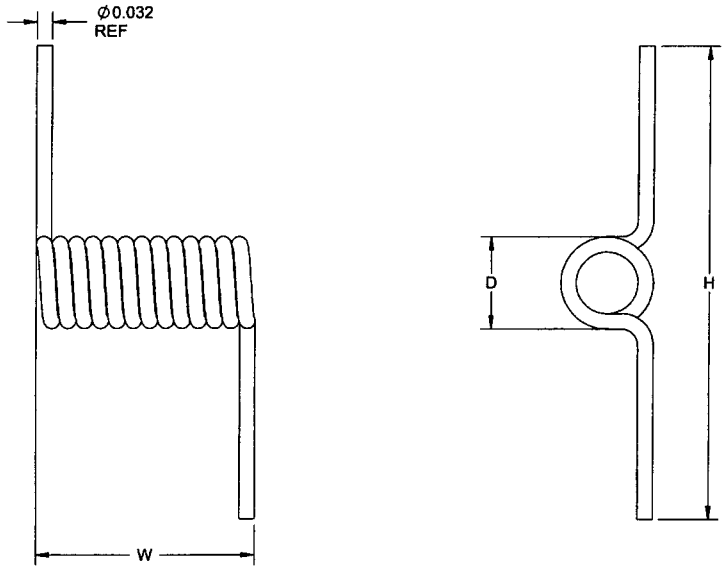
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-9	REF JCA-M47-2-26

SPECIFICATION CONTROL DRAWING





DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

D4008-X SPRING

RELEASED
2014 -06- 11

NOTES: (D)
1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE Ø0.032 PER ASTM A313
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: LESS THAN 0.01 lbs

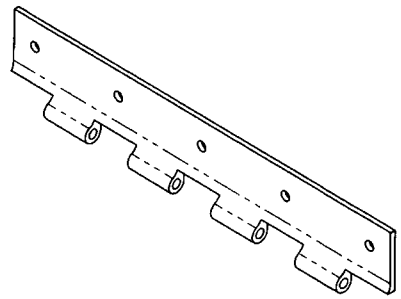
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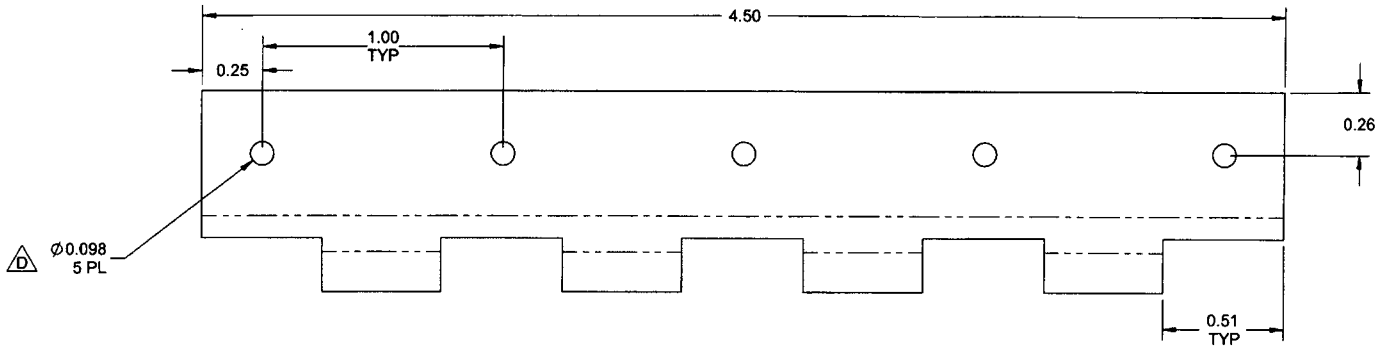
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DE APPR.	DS
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D4008-11 TANK HINGE HALF

RELEASED
2014 -06- 11
D

NOTES:
1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: STOCK AS D4008-11
7) WEIGHT: 0.01 lbs

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DRAWN	ML	
CHECKED	AP	DRAWING NO. D4008 REV. D
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APPROVED	MP	TITLE SPLASH GUARD SCALE NTS
DE APPR.	DS	
DATE	14.05.13	

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